

Work Order ID 150724

Tuesday, August 30, 2016 8:06:45 AM

150724**PRELIMINARY ISSUE**

Page 1

Item ID: D4060-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Bearpaw Clamp
Start Date: 8/31/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/6/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: em Date: 16/08/30 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4060	<u>pc11 rev C</u>								<u>PR 2016/08/31</u>
100		0.00							
100									
Waterjet	Memo	0.03							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>C11</u> Prog Rev: <u>C11</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 150724

Tuesday, August 30, 2016 8:06:45 AM

150724**PRELIMINARY ISSUE**

Page 2

Item ID: D4060-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: PRELIM Stop ***NS2***
Item Name: Bearpaw Clamp
Start Date: 8/31/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/6/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Form as per dwg	0.00							
130					DAS 30 9-89	4			SEP 14 2016
Brake NC	Memo	0.05							
Brake NC									
140	QC5- Inspect part completeness to step on W/O	0.00							
140						4			DAS 38 9-89 SEP 13 2016
QC	Memo	0.01							
Quality Control									
150	Identify as per dwg & Stock Location: PRELIM	0.00							
150						4			DAS 38 9-89 SEP 13 2016
Packaging	Memo	0.01							
Packaging						FX.			DAS 26 9-89 NOV 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

150724

Tuesday, August 30, 2016 8:06:45 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

4

Cust Item ID:

Start Date: 8/31/2016 **Start Qty:** 4.00

Required Date: 9/6/2016 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

160

0.07

QC

Memo

Quality Control

DAS
21
9-59

NOV 25 2016

**DAS
21
9-89**

OCT 14 2016

POSITIVE RECALL

EFFECTIVE 1965 AUTH

RELEASED 9 DATE 16-11-24

9-89

Rec

ENG 7100

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Tuesday, August 30, 2016 8:06:45 AM

PRELIMINARY ISSUE

Page 1

Work Order ID: 150724

150724

Parent Item: D4060-7

D4060-7

Parent Item Name: Bearpaw Clamp

Start Date: 8/31/2016

Required Date: 9/6/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 16.08.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased	No				sf	28.6158		0.215579			

M304S14GA

304SS sheet .080

**

PR 2016/08/31

Location

Loc Qty

Loc Code

MAT019

16.8

M129972

5.7

M135061

11.1

TPI

11.815791

M134604

11.815791

0.4

DQA: _____ Date: _____



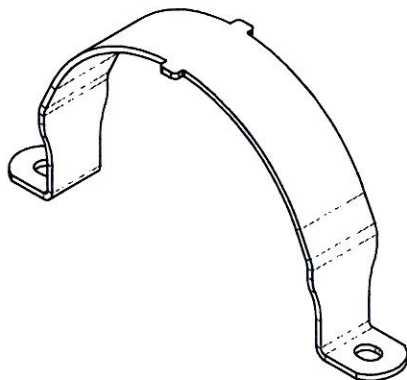
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

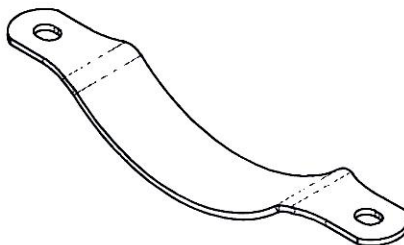
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

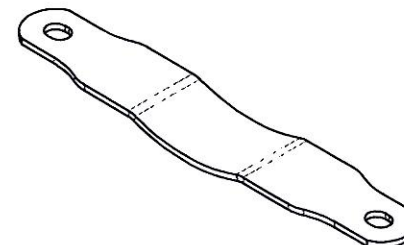
PRELIMINARY ISSUE



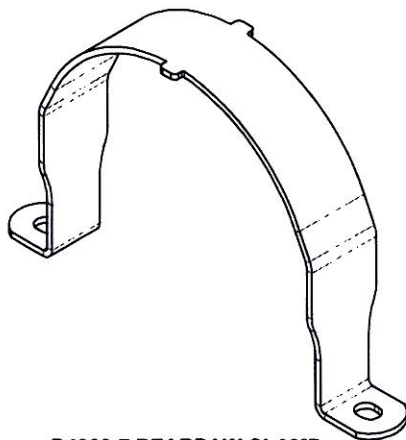
D4060-1 412 SKI CLAMP, TOP



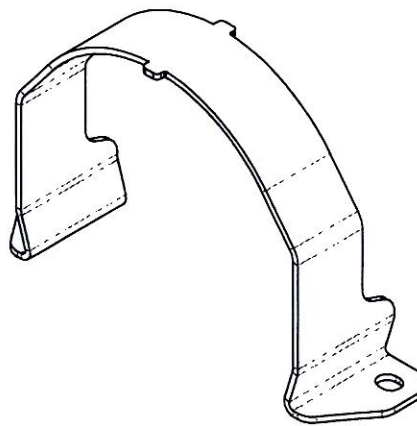
D4060-3 412 SKI CLAMP, BOTTOM



D4060-5 412 SKI CLAMP, AFT



D4060-7 BEARPAW CLAMP



D4060-9 AFT BEARPAW CLAMP

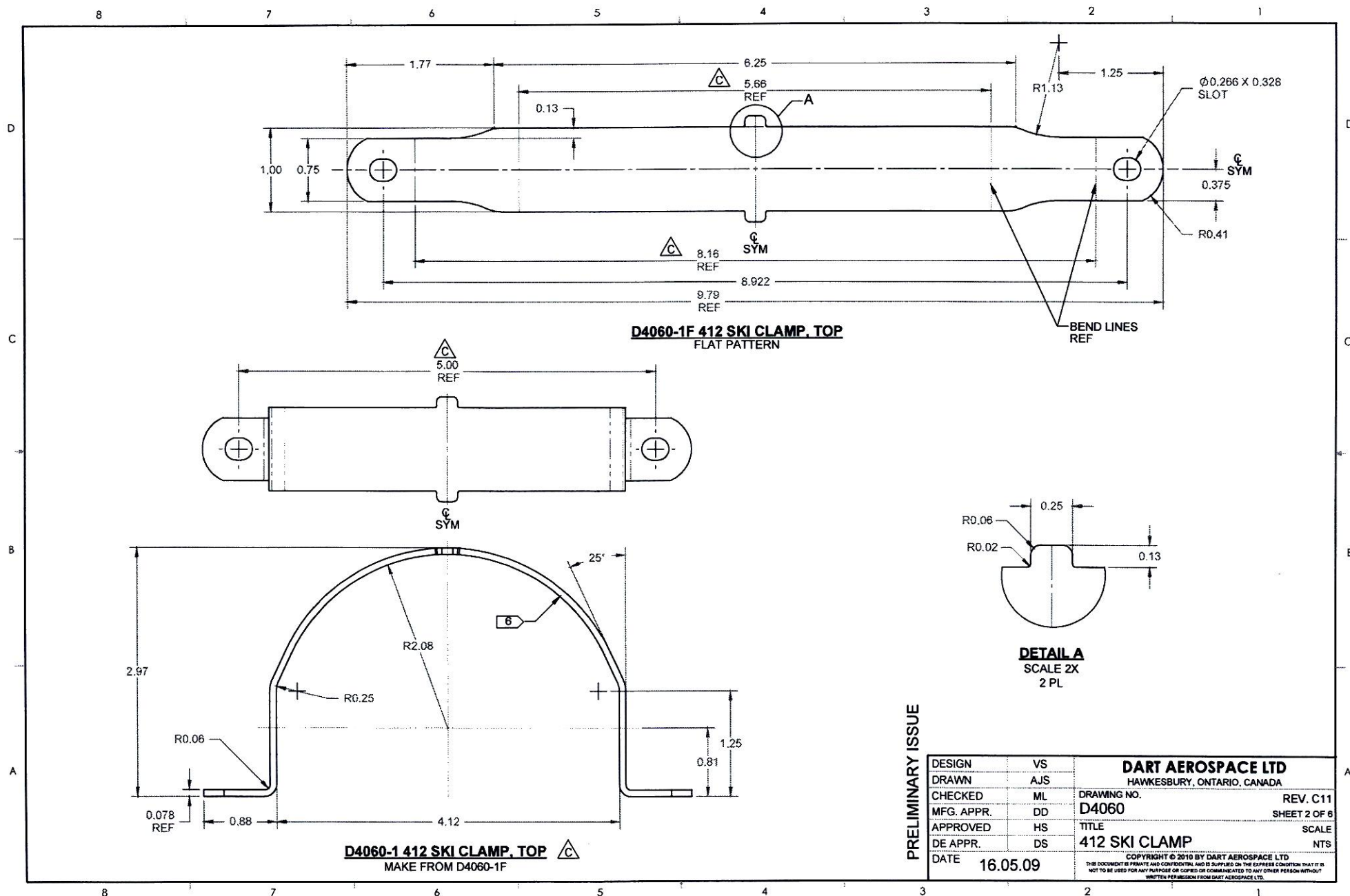
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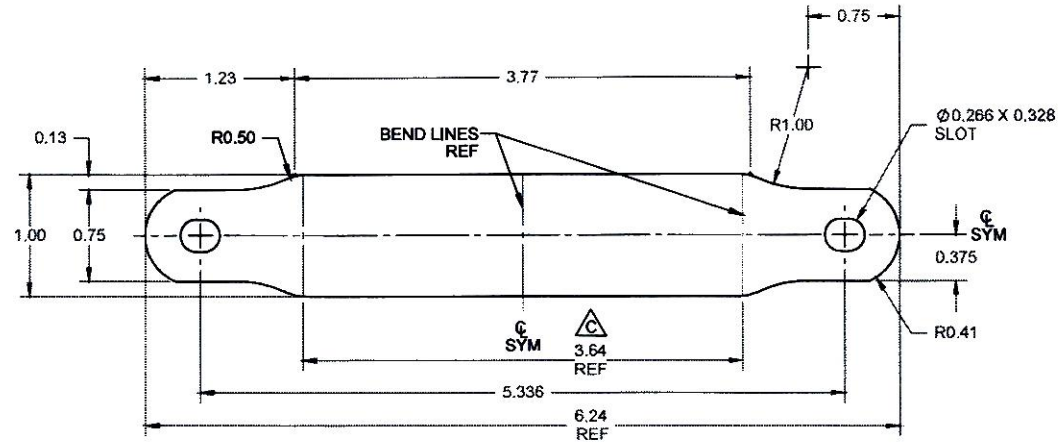
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: D4060-1/-7 = 0.23 lbs, D4060-3/-5 = 0.12 lbs, D4060-9 = 0.28

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 150724 *MJS*
16-08-30

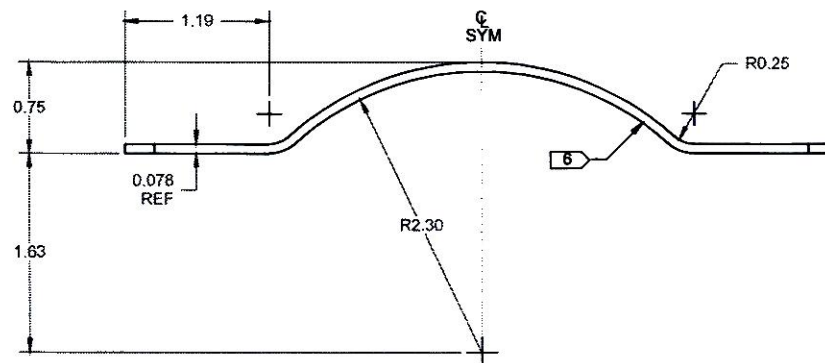
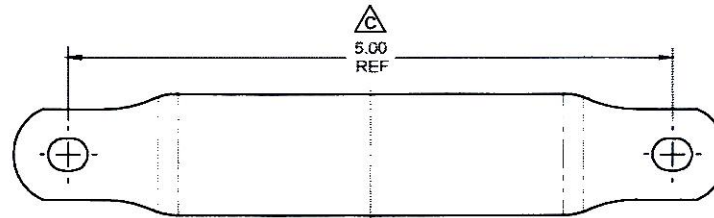
C	ADD -7 & -9. REASON: CIR16-67. ADD "REF" FOR BEND LINES.	AJS	16.05.09
B	ADD CUSHION RETENTION DETAILS TO -1 CLAMP. REASON: PAR 14-368, PAR 14-331, NCR 14-3521	VS	15.05.14
A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C11
MFG. APPR.	DD	D4060	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
DATE	16.05.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PRELIMINARY ISSUE





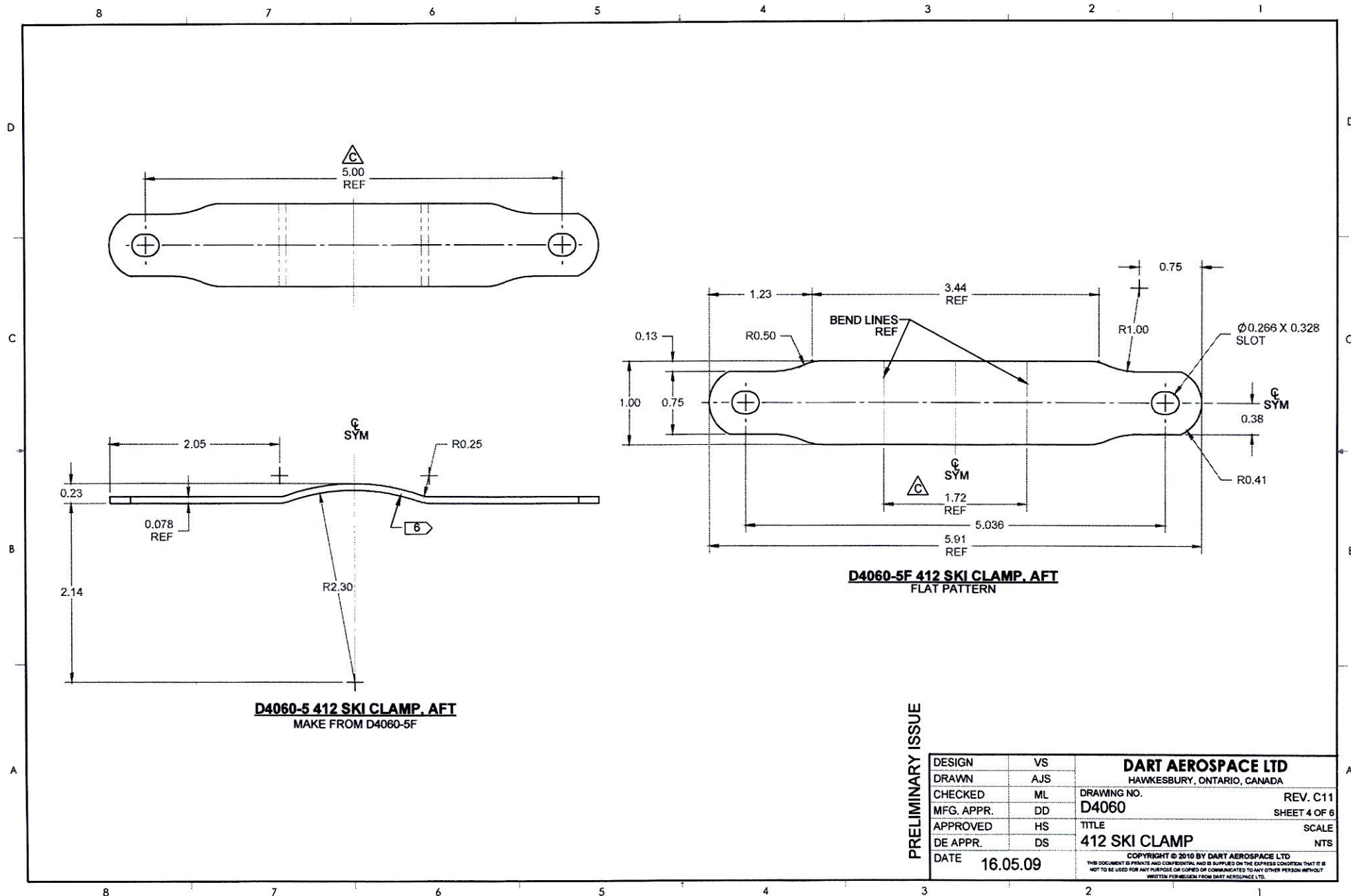
D4060-3F 412 SKI CLAMP. BOTTOM
FLAT PATTERN



D4060-3 412 SKI CLAMP. BOTTOM
MAKE FROM D4060-3F

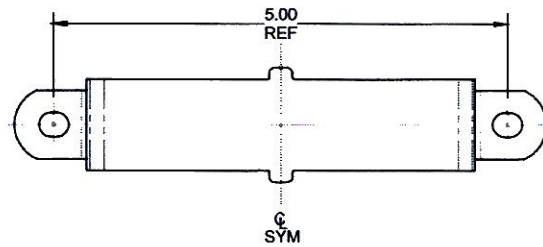
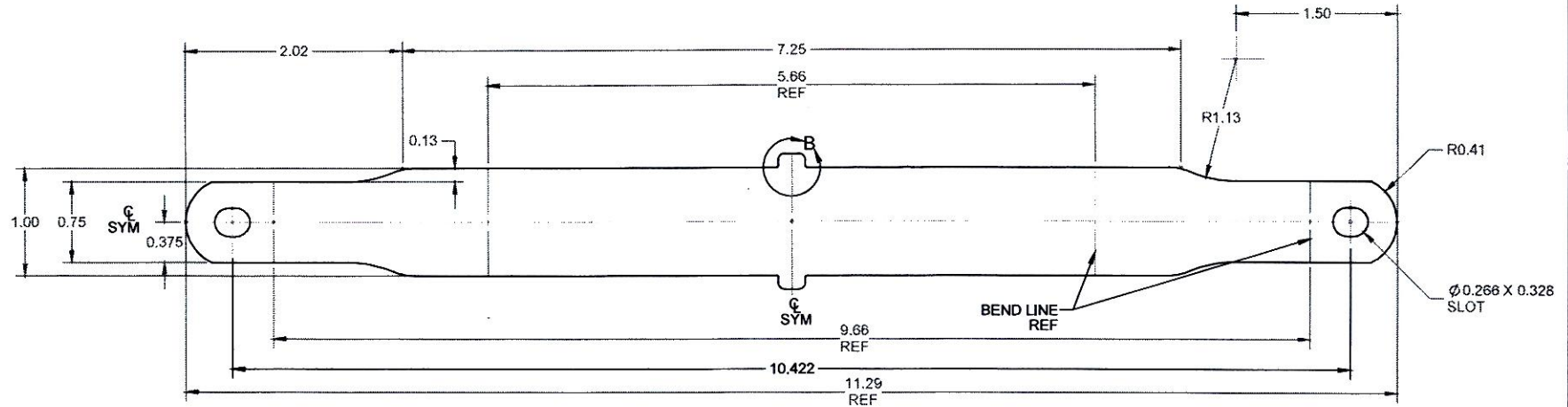
PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C11
MFG. APPR.	DD	D4060	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
DATE	16.05.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

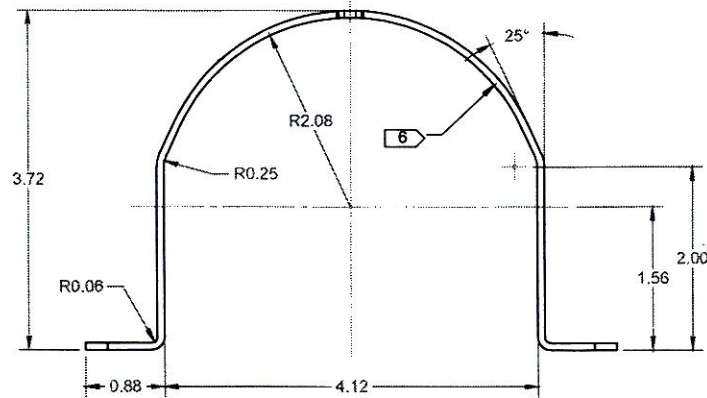


PRELIMINARY ISSUE

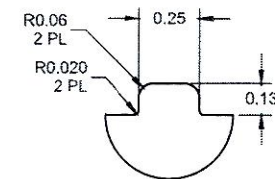
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C11
MFG. APPR.	DD	D4060	SHEET 4 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
DATE	16.05.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4060-7F BEARPAW CLAMP
FLAT PATTERN



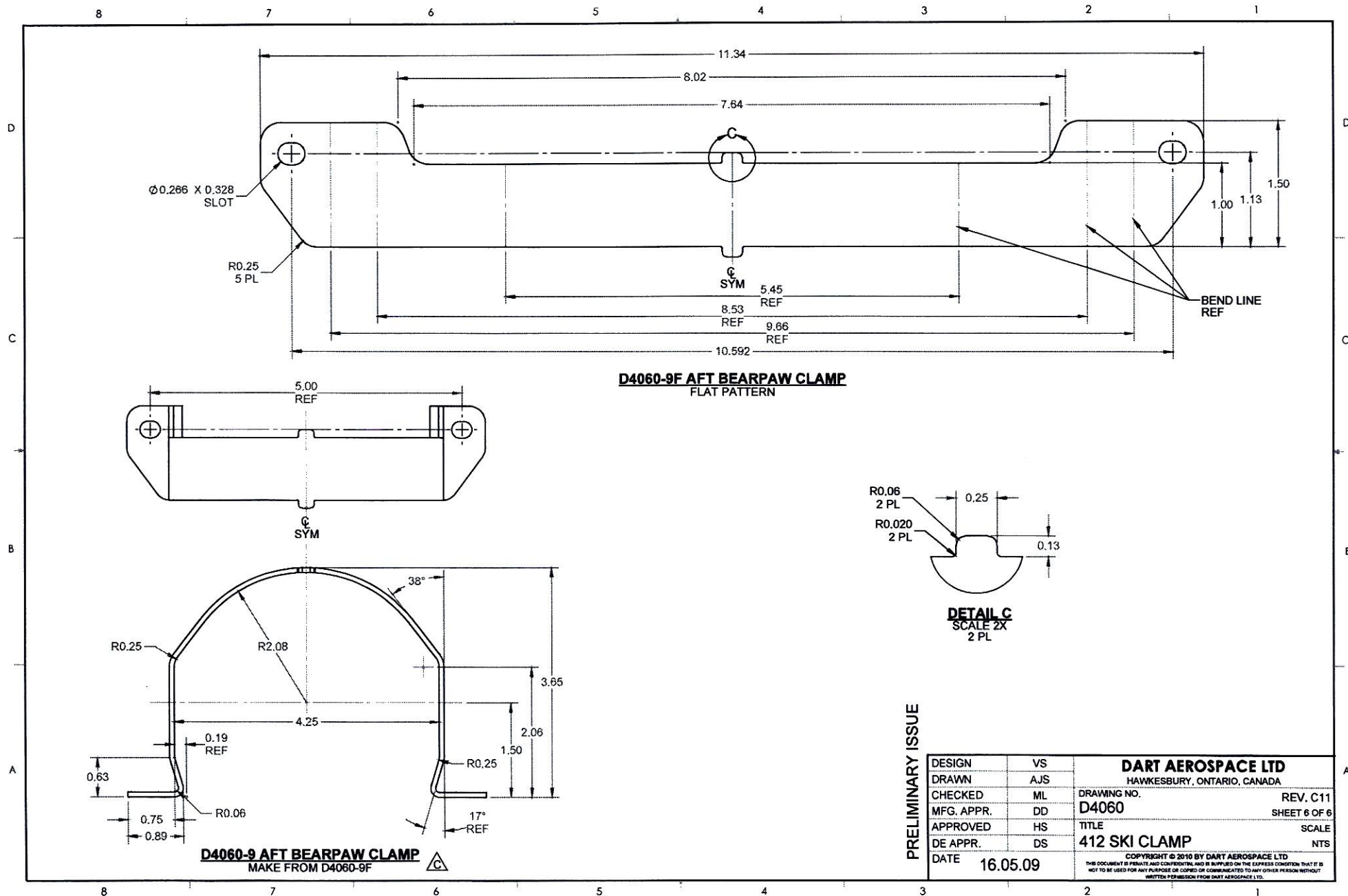
D4060-7 BEARPAW CLAMP
MAKE FROM D4060-7F



DETAIL B
SCALE 2X
2 PL

PRELIMINARY ISSUE

DESIGN	VS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C11
MFG. APPR.	DD	D4060	SHEET 5 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
DATE	16.05.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



8

7

6

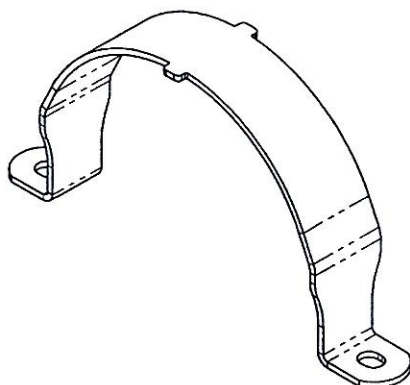
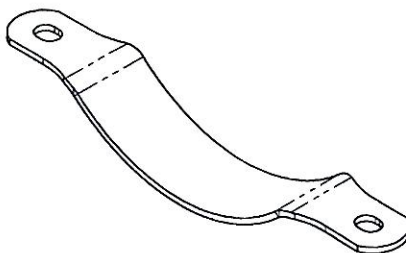
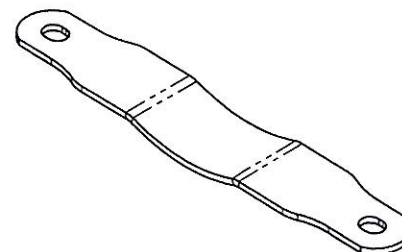
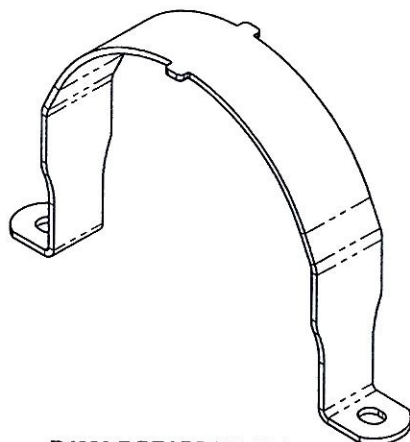
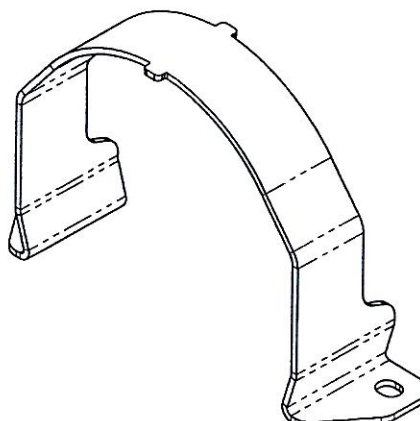
5

4

3

2

1

**D4060-1 412 SKI CLAMP, TOP****D4060-3 412 SKI CLAMP, BOTTOM****D4060-5 412 SKI CLAMP, AFT****D4060-7 BEARPAW CLAMP****D4060-9 AFT BEARPAW CLAMP****NOTES:**

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

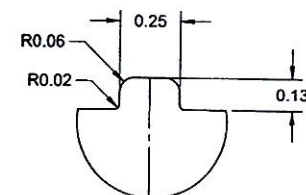
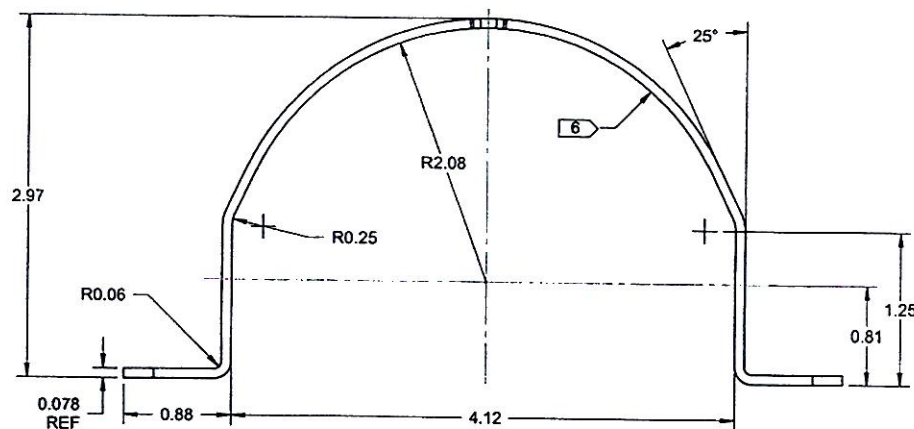
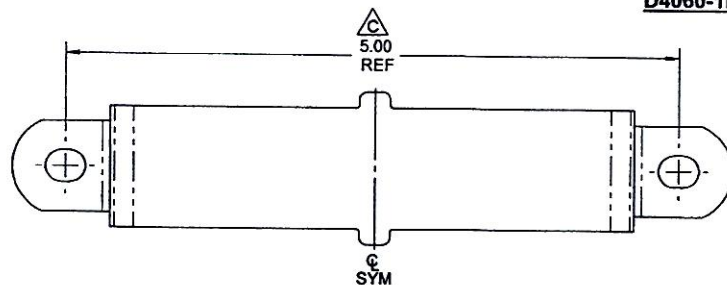
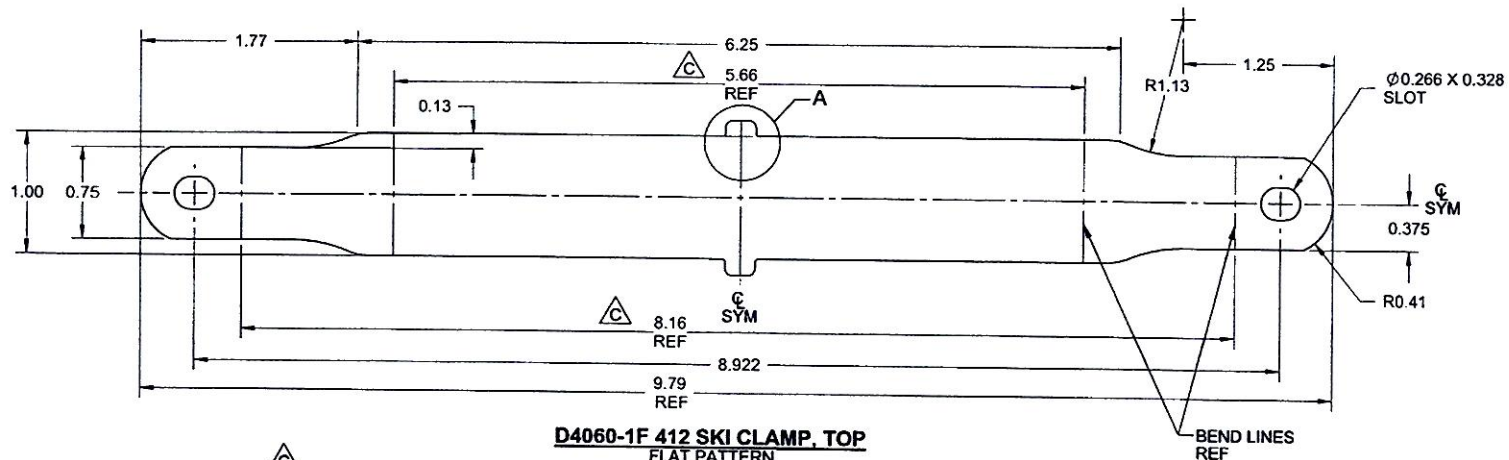
6) IDENTIFICATION: IDENTIFY PER DART QSI 044

7) WEIGHT: D4060-1/-7 = 0.23 lbs, D4060-3/-5 = 0.12 lbs, D4060-9 = 0.28

RELEASED
2016-10-18
EAW 16-654

APPROVED

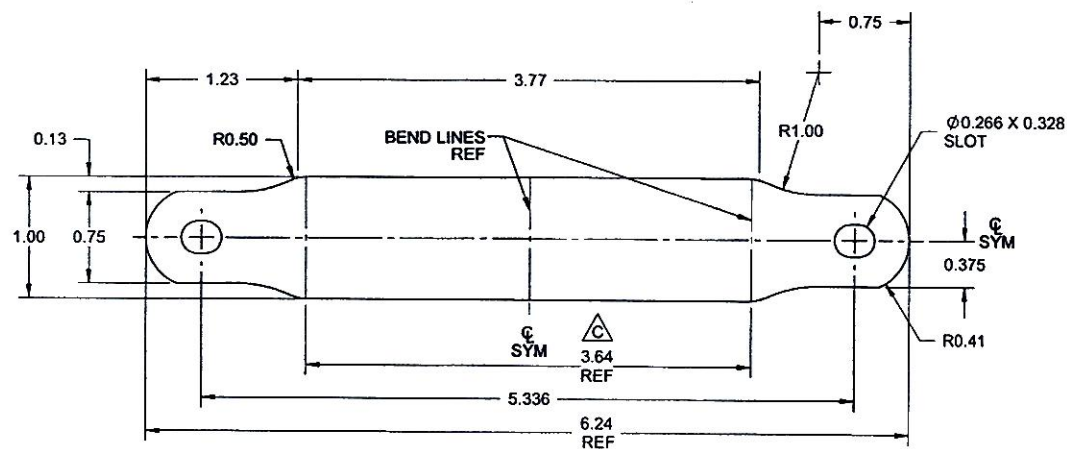
C	ADD -7 & -9. REASON: CIR16-67. ADD "REF" FOR BEND LINES.	AJS	16.05.09
B	ADD CUSHION RETENTION DETAILS TO -1 CLAMP. REASON: PAR 14-368, PAR 14-331, NCR 14-3521	VS	15.05.14
A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 1 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	412 SKI CLAMP	NTS
DATE	16.05.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



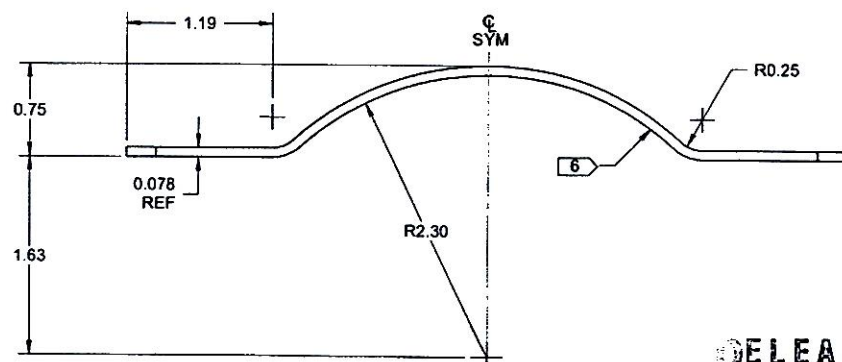
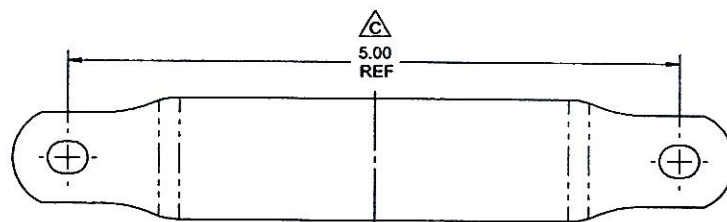
RELEASED
2016-10-18

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DESIGN	VS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 2 OF 6
APPROVED	WM	TITLE	SCALE
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D4060-3F 412 SKI CLAMP, BOTTOM
FLAT PATTERN

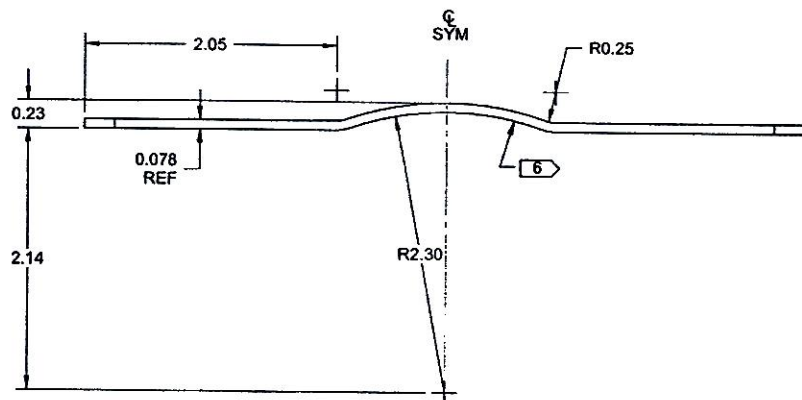
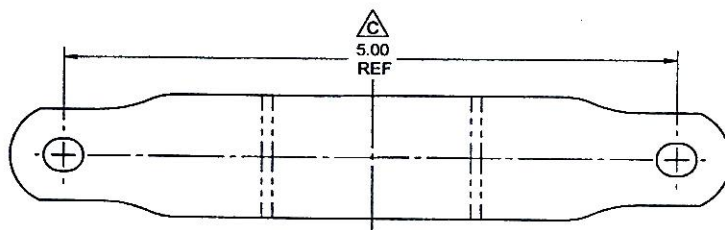


D4060-3 412 SKI CLAMP, BOTTOM
MAKE FROM D4060-3F

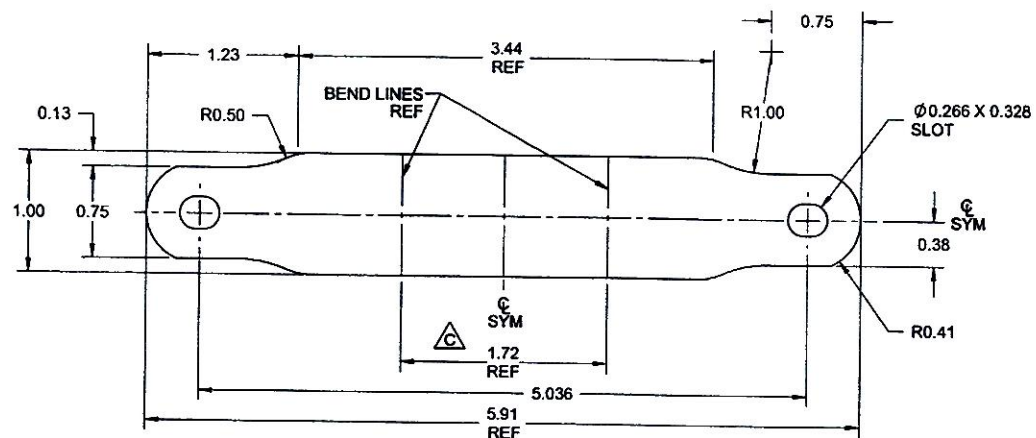
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2016-10-18

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. C
MFG. APPR.	DD	D4060	SHEET 3 OF 6
APPROVED	WM	TITLE	SCALE
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D4060-5 412 SKI CLAMP, AFT
MAKE FROM D4060-5F



D4060-5F 412 SKI CLAMP, AFT
FLAT PATTERN

RELEASED
2016-10-18

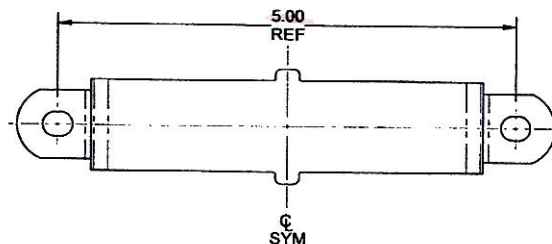
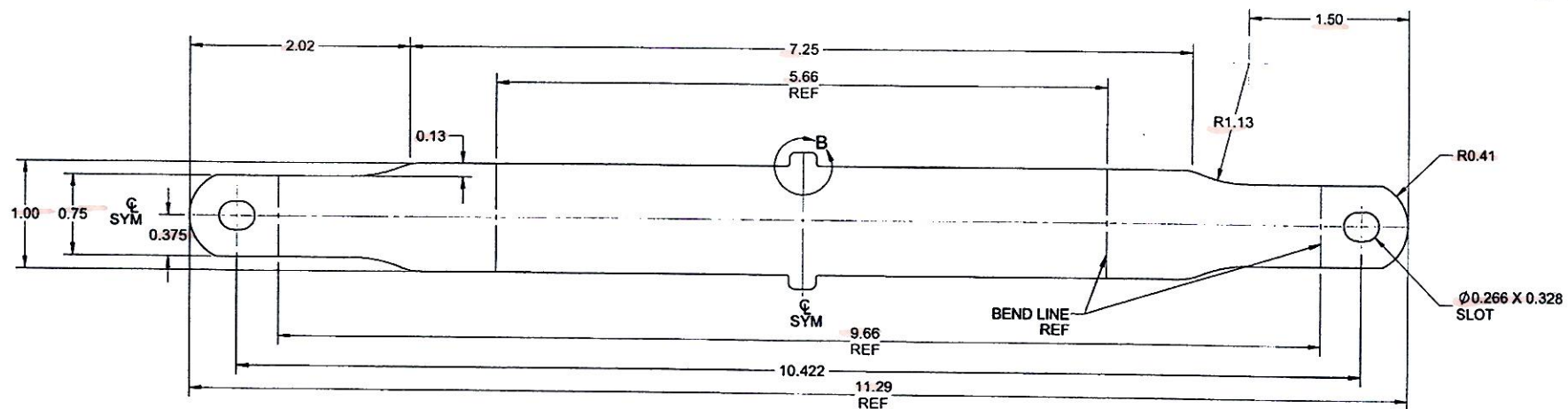
APPROVED

DESIGN	VS
DRAWN	AJS
CHECKED	ML
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.05.09

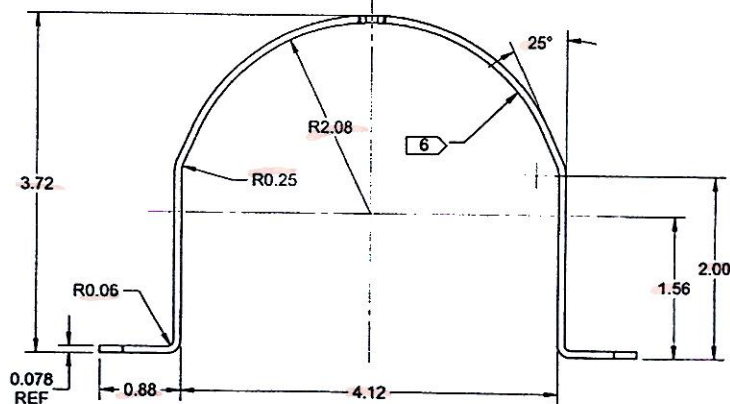
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. C
D4060	SHEET 4 OF 6
TITLE	SCALE
412 SKI CLAMP	NTS

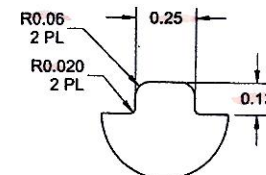
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D4060-7F BEARPAW CLAMP
FLAT PATTERN



D4060-7 BEARPAW CLAMP
MAKE FROM D4060-7F

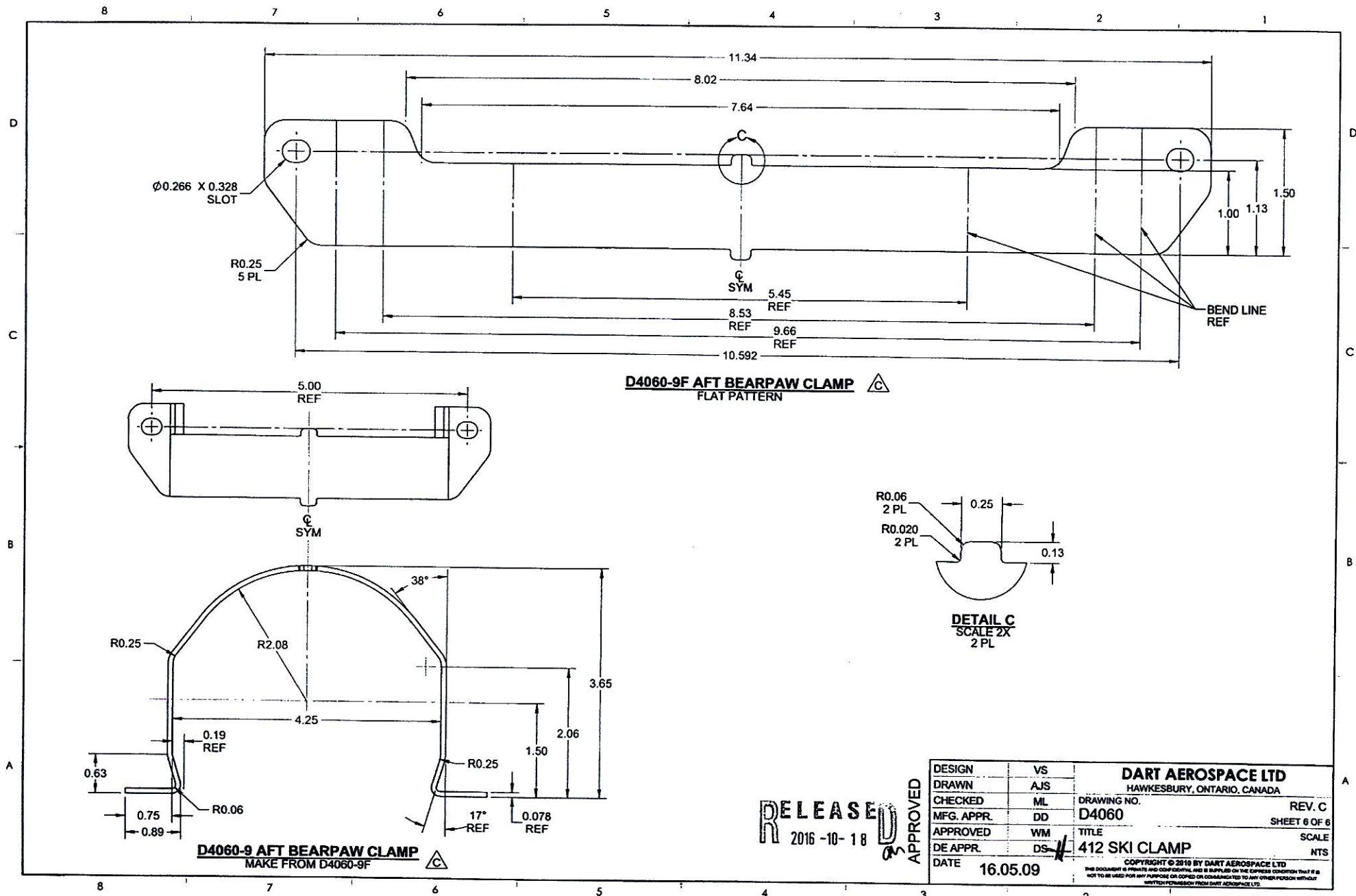


DETAIL B
SCALE 2X
2 PL

RELEASED
2016-10-18

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MFG. APPR.	DD	D4060	SHEET 5 OF 6
APPROVED	WM	TITLE	SCALE
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Valleyfield

Montréal
Tél.: 514 336-4248
Fax : 514 336-4246

Ontario
Tél.: 1 800 667-4248
Fax : 1 866 456-4242

www.aciercampi.com

613-632-5200 613-632-1053

EXPÉDIEZ À / SHIP TO :

EQUIP: LIFT

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

COMMANDE ORDER		N°	267190
DATE		20/06/16	
BON DE LIVRAISON PACKING SLIP		N°	
DATE DE LIVRAISON DELIVERY DATE		21/06/16	
REMARQUES / REMARKS		PAGE N°	001

VOTRE N° DE COMMANDE / YOUR P.O. N° P032767		VEND./SALESM. V	CODE CLIENT / CUST. CODE DAER	EXPÉDIER PAR / SHIP VIA 12345	TERMES / TERMS NET 30 JOURS	TERR. 2R	DELIVERY DATE 21/06/16		PAGE N° 001
CODE DE PRODUIT PRODUCT CODE	COMMANDE ORDERED	EXPÉDIÉ SHIPPED	DESCRIPTION		POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT	
PSS4814G	1		S.S. 304 2B 14 JA 48 X 96 1 X 4' X 8'		102.00				
PSS4816G	2		HEAT: X7DB S.S. 304 2B 16 JA 48 X 96 2' X 4' X 8' HEAT: X2VB		168.00				
					270				
* Unités de mesure : CLB Cent (100) livres Units of measure : CPI Cent (100) pounds Hundred pounds Hundred feet					UN Unit	PI Pieds Foot	PC Pied carré Square foot	POIDS TOTAL TOTAL WEIGHT	

CONDITIONS

LES MATÉRIAUX LIVRÉS ET FACTURÉS TELS QUE DÉCRITS DÉTERMINENT LA PROPRIÉTÉ DE CHACUN D'EUX. JUSQU'À PARFAIT PAIEMENT COMPLET ENCAISSÉ - LES RISQUES DE PÉRIE DU BIEN SONT À LA CHARGE DE L'ACHETEUR. - LE CLIENT AVEU DE QUALITÉ DU MATÉRIEL ET LA PAIEMENT QUE CELLE DU FABRICANT. - L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES : 1) NET 30 JOURS DE LA DATE DE FACTURATION ET TOUT COUT D'EXPÉDITION, 2) S'IL Y A DES DÉLAIS EXTRAORDINAIRES DE FRAS DE 20 PAR MOIS (24% PAR ANNEE) DUT ACCEPTÉ DE PAYER, 3) TOUT DÉFAUT D'EXÉCUTION (UNE OU L'AUTRE) DES OBLIGATIONS DU CLIENT ENVERS LE Vendeur, 4) LE DÉLAIS DE DÉCÉDANT DU TERME ET PÉRIODE AU Vendeur, 5) SON CHOIX DE RÉCLAMER TOUT SOLDE DOCUMENT - TOUTE MARCHANDISE ENDOGMÉE, ALTÉRÉE OU COUPÉE NE PEUT ÊTRE REPRISE, 6) AUCUN RETOUR DE MARCHANDISE NE SERA ACCEPTÉ SANS NOTRE AUTORISATION. - TOUTE MARCHANDISE RETOURNÉE EST SUJETTE À DES FRAS DE MAINUTENANCE DE 25%.

CONDITIONS : ALL SOLID AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "ACHEN CAMP" UNTIL PAYMENT IS MADE FULL, COMPLETE AND CASHED. - ALL LOST MATERIALS ARE AT THE BUYER'S EXPENSE. - ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. - THE BUYER HEREBY ACCEPTS TO RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM INVOICE DATE AND THE BUYER ACCEPTS TO PAY ADMINISTRATION CHARGES OF PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OF THIS CONTRACT WILL LEAD TO ANY AND ALL DAMAGES THAT MAY BE INCURRED BY THE BUYER. - ALL GOODS RETURNED MUST BE WITH DOCUMENT ENCLOSED. - ANY MERCHANDISE THAT HAS BEEN DAMAGED, OILY OR MODIFIED CANNOT BE RETURNED. - ALL FIVE DOLLARS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE SUBJECT TO A 25% RESTOCKING CHARGE.

PREPARE PAR/PREPARED BY	VERIFIE PAR / VERIFIED BY
-------------------------	---------------------------

LIVRE PAR / DELIVERED BY	HEURE / TIME
--------------------------	--------------

MARCHANDISE RECUE EN BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION			
	A/Y	M/M	J/D
X			

SOUS-TOTAL SUB TOTAL
T.P.S. G.S.T.
T.V.Q. / T.V.H. G.S.T. / H.S.T.
TOTAL

Nº ENR. TPS / GST REG. Nº 822 435 970 RT 0001 • Nº ENR. TVQ / QST REG. Nº 122 127 8280 TQ 0001

SIGNATURE DU CLIENT / CUSTOMER'S SIGNATURE

DATE _____



740 Imperial Road North

Certificate: 145644 1 Mail To:

Customer: 007035 510

METALLURGICAL TEST REPORT

North American Stainless Canada Inc.
740 Imperial Road North
Guelph, ON N1K1Z3
Canada

Ship To:

Date: 3/22/2016 Page: 1

Steel: 304

Finish: 2B

Corrosion: ASTM A262/14 A; 182 Bend OK

Your Order: 774450

NAS Order: PN 0060108 02

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, C.R. ANNEALED & PICKLED; UNS 30400
ASTM A240/15a, A480/14b, A666/15, ASME SA380/13, SA480/13, SA666/13
CHEM ONLY ON FOLLOWING ASTM: A276/13, A479/13a, A484/13a, A312/13
CHEM ONLY ON FOLLOWING ASME: SA312/13, SA479/13
AMS 5513V XM1K; MIL-8-5059D AMEND3 (X CROWN HEAS)
NACE MR0175/ISO 15156-3:2009 A, MR0103/07; Q3766D-A X MAG PERM
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; RoHS 1 & 2 Compliant
Material is Free of Radioactive Contamination
Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant

DAS
48
0.80

Product Id	Coil #	Skid #	Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
04X7D8 A	04X7D8 A	0725	48.0000	10.350	COIL			5	74266941

CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan) Lab Accreditation Bureau, ISO/IEC 17025, Certificate# L2323
Chemical Analysis per ASTM A751/08

HEAT	CM	C %	CR %	CU %	MN %	MO %	N %	NI %	P %	S %
04X7D8	US	.0684	18.1330	.4215	1.7985	.3050	.0637	8.0970	.0310	.0010
SI %										
.3045										

MECHANICAL PROPERTIES

Product Id#	Coil #	1 d	UTS	20C	.2% YS	20C	ELONG	%	Hard	Tail	Grain
		o 1	KSI		KSI		%-2"		RB	Hard	No.
04X7D8 A	04X7D8 A	F T	104.35		55.04		45.44		91.00	86.00	9.00

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
Dept. Mgr.

KRIS LARK

2/22/2016

ACIER CAMPI INC. P.O. - 69039 ET 69032 S.O. - 372289

PSS 48146

69032



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32767**

Purchase Order Date 6/20/2016

PO Print Date 6/20/2016

Page Number 2 of 6

Order From :

VC-CAM002

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 800 667 4248

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA (Free Carrier)

3	M303B1.000X1.000	303 BAR 1" X 1"	6/27/2016	12.00	\$19.30	\$231.65
			Yes	f		
			6/27/2016			

MATERIAL: AISI 303 SS BAR AS PER ASTM A582
NOTE: AISI 304/316 NOT ACCEPTABLE

Line Total: \$231.65

4	M304B0.500X2.500	304 BAR .500 x 2.50	6/28/2016	12.00	\$10.95	\$131.40
			Yes	f		
			6/28/2016			

MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS
AS PER ASTM A276 OR ASTM A240

NOTE: AISI 303 NOT ACCEPTABLE

Line Total: \$131.40

5	M304S14GA	304SS sheet .080	6/22/2016	32.00	\$8.13	\$260.05
			Yes	sf		
			6/22/2016			

MATERIAL: AISI 304/316 SS SHEET
ANNEALED
SPECIFICATION: MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240

SP/16-6-22

PO Instructions: QUOTE # 386791,386554,386266,386708

Note:

6/20/2016